

Work Order ID 128082

128082

Tuesday, January 06, 2015 9:25:37 AM

Page 1

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Stop *NS2*
 Compatible
 Start Date: 1/6/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-06 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Rate Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100 Document Control 0.00
 100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork

record fwd angle: 89.7°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

15-1-7 

Work Order ID 128082

Tuesday, January 06, 2015 9:25:37 AM

128082

Page 2

Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop

NS2

Start Date: 1/6/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

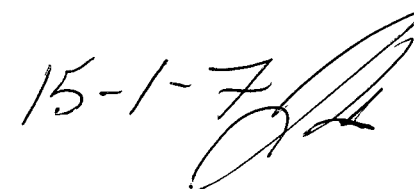
Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)								
	4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail J to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								



15-1-7



BE15-01-07

Work Order ID 128082

Tuesday, January 06, 2015 9:25:37 AM

128082

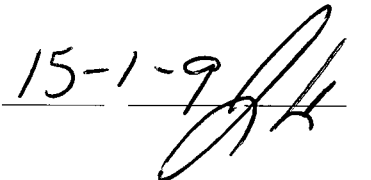
Page 4

Item ID: D350-636-012**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop*****NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start***NR1*****Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									



Work Order ID 128082

Tuesday, January 06, 2015 9:25:37 AM

128082

Page 5

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/6/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Dwg Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160	Skidtubes								
Skidtubes	Memo 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131120</u> exp. date: <u>15-10-21</u> 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M130812</u> 9- At section AP-AP drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per	0.00							

15-1-9

78E 15-01-12

Del 15-1-13

Work Order ID 128082

Tuesday, January 06, 2015 9:25:37 AM

128082

Page 6

Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							DAS 9 9-89
Quality Control	***VERIFY C'BOARD IS GOOD***								

Tuesday, January 06, 2015 9:25:37 AM

Page 7

IRH of All 1502/10

Work Order ID 128082

Tuesday, January 06, 2015 9:25:37 AM

128082

Page 8

Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/6/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 *230* HandFinish Hand Finishing	HandFinishing Memo 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M131120</u> EXP DATE: <u>15/06</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M1131349 RTU 5481341 M1125792 exp15/06</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>M122900</u>	0.00 0.00				<u>1</u>	<u>4</u>	<u>11</u>	<u>15/02/15</u>
240 *240* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>1</u>			

DAS
38
9-89

FEB 20 2015

Work Order ID 128082

Tuesday, January 06, 2015 9:25:37 AM

128082

Page 10

Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 15-03-16

AS-3-13

Picklist Print

Tuesday, January 06, 2015 9:25:40 AM

Page 1

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH *D2600-3-BFNT-RH* Extrusion Bent RH		Manufactured	No			110	Each	12.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				12					
				125888				12					
D2744 *D2744* Cap		Manufactured	No			110	Each	38.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				38					
				125894				38					
D2739 *D2739* 350 I Beam		Manufactured	No			160	Each	13.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG003				13					
				125889				13					

**

**

**

15-1-7

BB 15-01-07

15-1-9

Picklist Print

Tuesday, January 06, 2015 9:25:40 AM

Page 2

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2743

Manufactured No

160

Each

Start Qty: 1.00
155.0000 8 8

Required Qty: 1.00

D2743

Crossbolt Spacer

**

BE15-01-12

Location

Loc Qty

Loc Code

LG001

155

125893

8

127636

147

B

D3490-3

Manufactured No

160

Each

107.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE15-01-12

Location

Loc Qty

Loc Code

LG001

107

125903

107

H

D3490-1

Manufactured No

160

Each

117.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE15-01-12

Location

Loc Qty

Loc Code

LG001

117

125902

117

H

D3631-1

Manufactured No

230

Each

186.0000 8 8

D3631-1

Washer

**

13120320

Location

Loc Qty

Loc Code

FP001

186

125912

186

13120320

X8

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 3

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3791-1

Manufactured No

230

Each

38.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3791-1

Wearpad

**

all 15/02/19

Location

Loc Qty

Loc Code

FP002

38

B126317

125913

38

xl

D3793-3

Manufactured No

230

Each

40.0000

1

1

D3793-3

Wearplate Aft

**

all 15/02/19

Location

Loc Qty

Loc Code

FP002

40

B128236

125915

40

xl

MS21043-6

Purchased No

230

Each

214.0000

4

4

MS21043-6

NUT

**

all 15/02/19

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

194

m130325

6

m130726

188

xl

D3794-1

Manufactured No

230

Each

36.0000

1

1

D3794-1

Gasket Fwd

**

all 15/02/19

Location

Loc Qty

Loc Code

FP001

36

124438

1

125916

35

xl

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 4

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-010

Purchased

No

230

Each

Start Qty: 1.00
188.0000 8 8

Required Qty: 1.00

NAS1611-010

O-RING

**

all 12/2/14

Location

Loc Qty

Loc Code

FP001

188

1131329

m130797

188

KG

D2741

DAS

Manufactured

No

250

Each

11.0000

1

1

D2741

43

Replacement Blade

9-11

**

128082

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

124047

1

NAS1515H3L

Purchased

No

230

Each

695.0000

4

4

***NAS1515H3I ***

Washer

**

all 12/2/14

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

99

m127831

99

ST266

556

m127831

56

m130726

500

Y4

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 5

Work Order ID: 128082

128082

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D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-013

Purchased

No

230

Each

958.0000

Start Qty: 1.00

8

8

Required Qty: 1.00

NAS1611-013

O-RING

**

all 15/02/19

Location

Loc Qty

Loc Code

FP001

958

m130758

958

v8

AN3C6A

Purchased

No

230

Each

616.0000

4

4

AN3C6A

Bolt

**

all 15/02/19

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

126

m128769

126

ST338a

441

m128769

441

x4

NAS1149C0832R

Purchased

No

230

Each

191.0000

1

1

NAS1149C0832R

Washer

**

all 15/02/19

Location

Loc Qty

Loc Code

FP001

47

m114915

47

ST271

144

m125807

144

v1

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 6

Work Order ID: 128082

128082

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D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3536-25

Manufactured No

230

Each

38.0000

Start Qty: 1.00

1 1

Required Qty: 1.00

D3536-25

Gasket Center

**

all 1/5/02/19

Location

Loc Qty

Loc Code

FG

6

B128578

87053

2

✓

95328

4

FP001

32

125909

32

D3794-3

Manufactured No

230

Each

75.0000

1

1

D3794-3

Gasket Aft

**

all 1/5/02/19

Location

Loc Qty

Loc Code

FP001

75

124948

1

125917

34

X1

127383

39

92658

1

AN3C5A

Purchased No

230

Each

1,165.000

34

34

AN3C5A

Bolt

**

all 1/5/02/19

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

17

M130851

17

ST338a

1143

M130770

1000

X34

M130851

143

Tuesday, January 06, 2015 9:25:41 AM

Shop Packet Print

Page 6

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 7

Work Order ID: 128082

128082

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3537-1

Manufactured No

230

Each

67.0000

Start Qty: 1.00

3

3

Required Qty: 1.00

D3537-1

Wearpad

**

lll 15/02/19

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

49

125418

3

126306

46

B128225

v3

D3535-25

Manufactured No

230

Each

10.0000

1

1

D3535-25

Wearplate Center

**

lll 15/02/19

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

8

125908

8

x1

D3492-3

Manufactured No

230

Each

210.0000

8

8

D3492-3

Plug

**

lll 15/02/19

Location

Loc Qty

Loc Code

FP001

210

125905

210

B128476

v8

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 8

Work Order ID: 128082

128082

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Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00
4,519.000 38 38

Required Qty: 1.00

NAS1149C0332R

WASHER

**

all 15/02/19

Location

Loc Qty

Loc Code

FP001

2657

11131340

v38

m130325

2657

GA

126

125654

126

ST271

1736

m130325

736

m130466

1000

D3488-042

Manufactured

No

230

Each

2.0000

1

1

D3488-042

Blade Fitting RH

**

all 15/02/19

Location

Loc Qty

Loc Code

FP001

2

B125899

125901

2

v1

ALS4-1032-225

AELS8-1032-225

Purchased

No

230

Each

1,622.000

38

38

ALS4-1032-225

Rivnut

**

all 15/02/19

Location

Loc Qty

Loc Code

FG

120

M127028

120

11131582

v38

FP001

698

M131067

698

st549

804

M131067

804

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 9

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128082

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3492-1

Manufactured No

230

Each

Start Qty: 1.00
189.0000 8 8

Required Qty: 1.00

D3492-1

Plug

**

lll 15/02/19

Location

Loc Qty

Loc Code

FP001

189

125904

189

B128509

28

D3793-1

Manufactured No

230

Each

44.0000

1

1

D3793-1

Wearplate Fwd

**

lll 15/02/19

Location

Loc Qty

Loc Code

FP002

44

125914

43

B128235

21

126905

1

AN8C35A

Purchased No

230

Each

27.0000

1

1

AN8C35A

Bolt

**

lll 15/02/19

Location

Loc Qty

Loc Code

FG

5

121275

5

X1131367

21

FP001

22

m130114

1

m130784

21

MS21083C8

Purchased No

230

Each

116.0000

1

1

MS21083C8

Nut

**

lll 15/02/19

Location

Loc Qty

Loc Code

ST300

116

m131049

116

21

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 10

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2745

Manufactured No

230

Each

92.0000

Start Qty: 1.00

8

8

Required Qty: 1.00

D2745

Bushing

**

15/02/14

Location

Loc Qty

Loc Code

FP001

92

B128920

x 8

125895

92

AN6C44A

Purchased

No

230

Each

110.0000

4

4

**

15/02/14

AN6C44A

Bolt

Location

Loc Qty

Loc Code

FG

2

103964

2

1131546

x 1

FP001

4

m130863

4

ST286A

17

m130863

17

ST332

11

m130863

11

ST333

76

m131151

76

D3532-1

Manufactured

No

250

Each

32.0000

2

2

**

DAS

27

9-89

MAR 02 2015

D3532-1

Spacer

DAS

43

9-89

Location

Loc Qty

Loc Code

ST048

32

125907

32

B128091

2

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 11

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

MS21083C8

Purchased

No

250

Each

116.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

MS21083C8

DAS

Nut

**

DAS

27

9-89

MAR 02 2015

Location

Loc Qty

Loc Code

ST300

116

m13/618

2

m131049

116

NAS1149D0863J

Purchased

No

250

Each

758.0000

2

2

NAS1149D0863J

DAS

Washer

**

DAS

27

9-89

MAR 02 2015

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

700

125268

600

125635

100

st268

1

125268

1

D3493-1

Manufactured

No

250

Each

109.0000

2

2

D3493-1

DAS

Washer

**

DAS

27

9-89

MAR 02 2015

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

99

125906

99

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

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Shop Packet Print

Page 11

Picklist Print

Tuesday, January 06, 2015 9:25:41 AM

Page 12

Work Order ID: 128082

128082

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

AN8C21A

Purchased

No

250

Each

20.0000

Start Qty: 1.00

2

2

Required Qty: 1.00

AN8C21A

DAS
46
9-89

**

DAS
27
9-89

Bolt

Location

Loc Qty

Loc Code

MAR 02 2015

FG

2

123966

2

ST332

18

m131100

18

m131547

2

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø.0297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

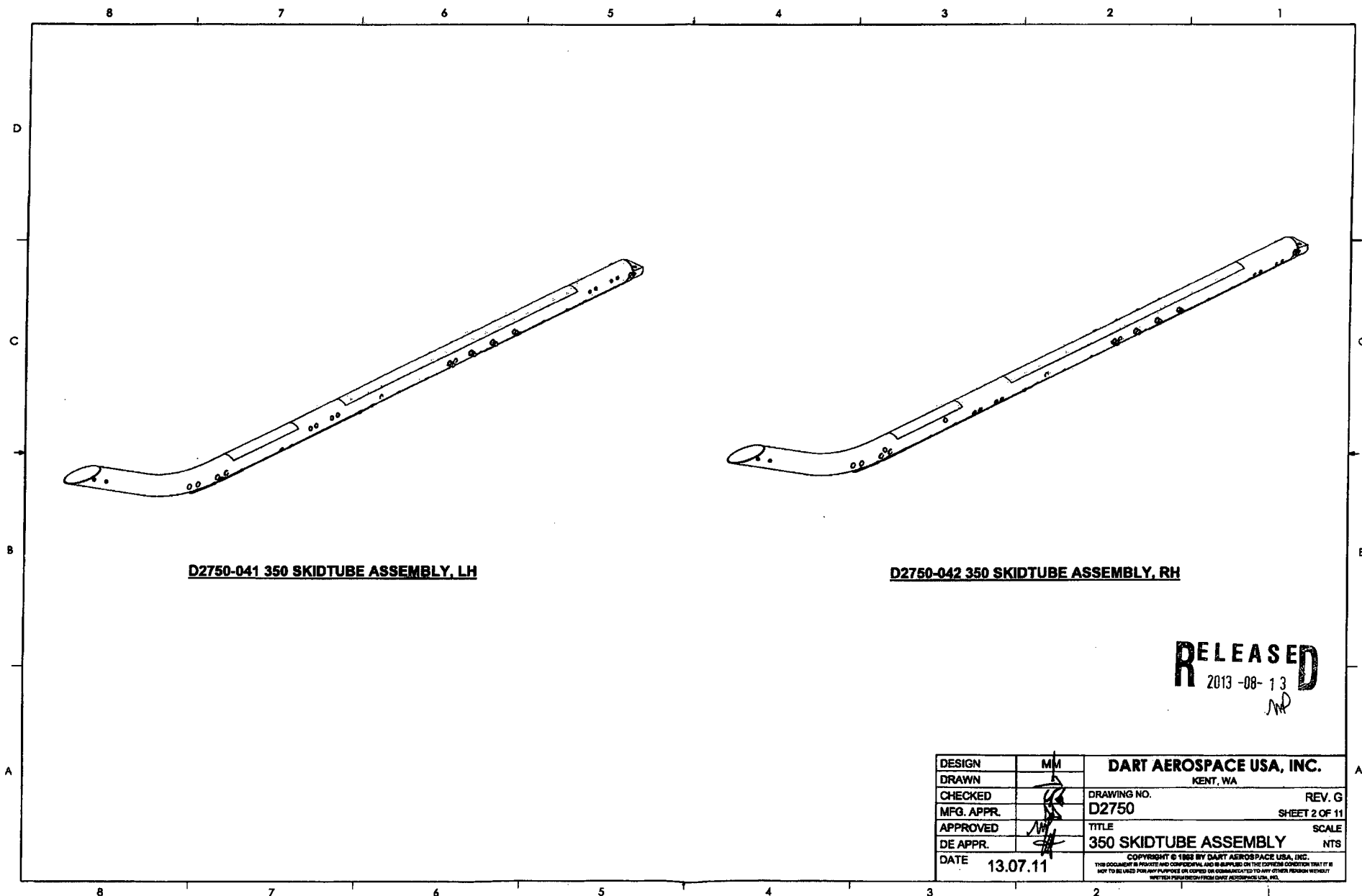
128082_MLT
1501-06

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WD

G	CORRECTED TOLERANCE ON Ø.0500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DSO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.08.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

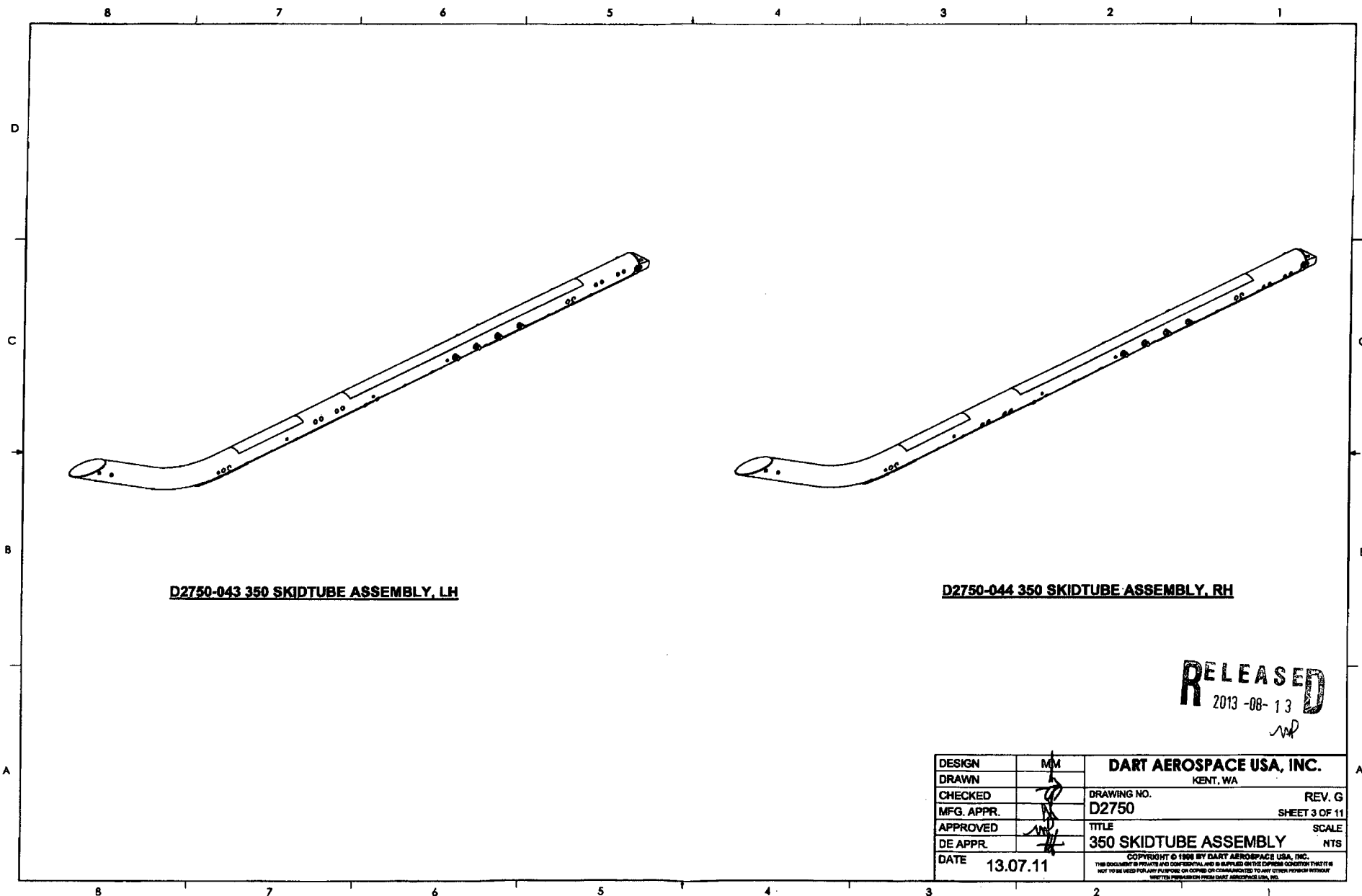
DART AEROSPACE USA, INC.
KENT, WA
DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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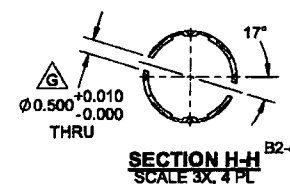
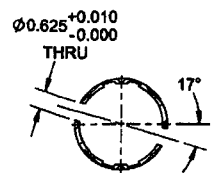
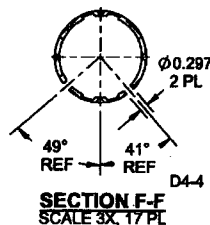
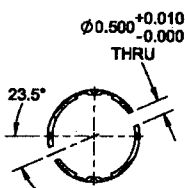
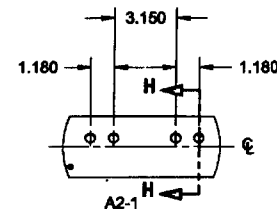
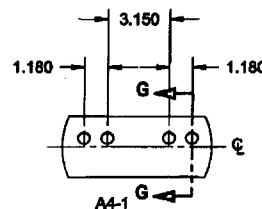
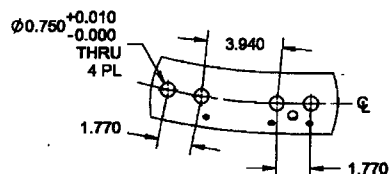
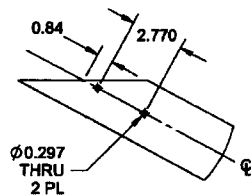
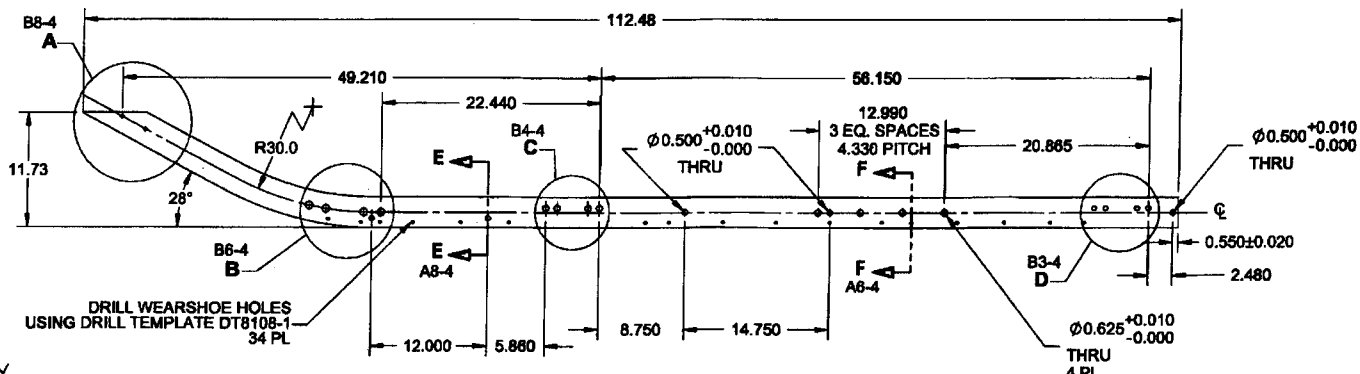


D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

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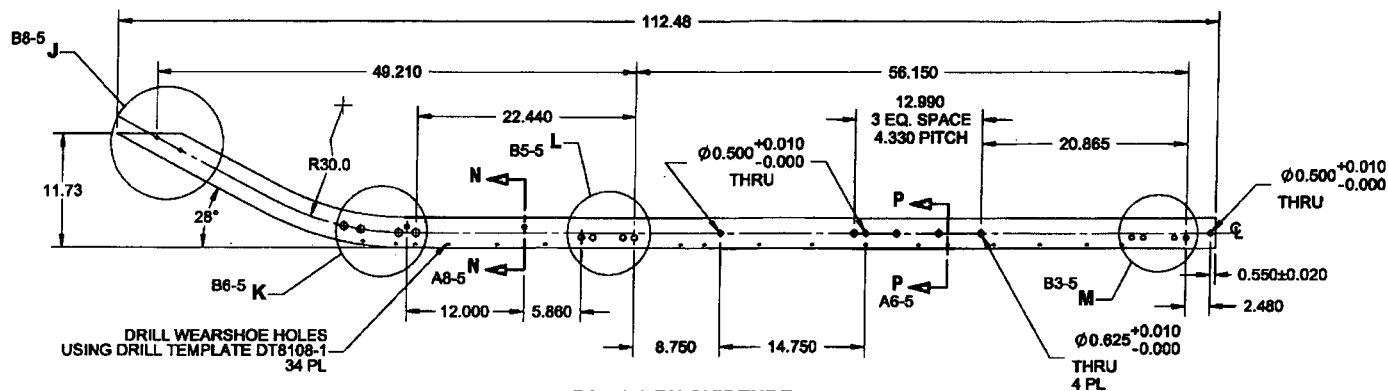
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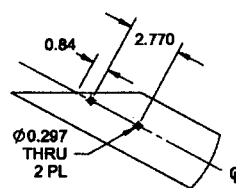
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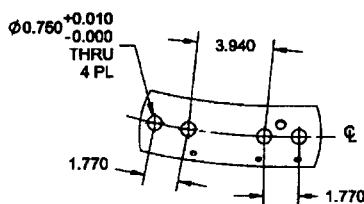
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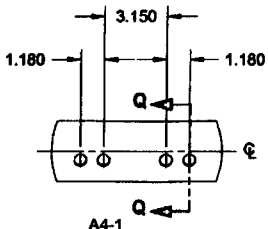
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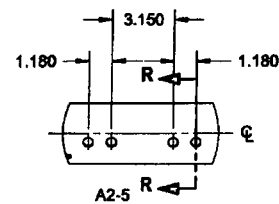
D8-5
DETAIL J
SCALE 2X



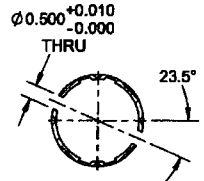
C7-5
DETAIL K
SCALE 2X



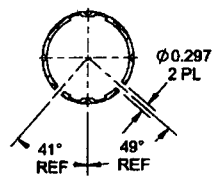
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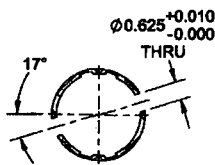
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DETAIL M
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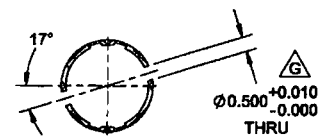
C6-5
SECTION N-N
SCALE 3X, 2 PL



C4-5
SECTION P-P
SCALE 3X, 17 PL



B5-5
SECTION Q-Q
SCALE 3X, 4 PL

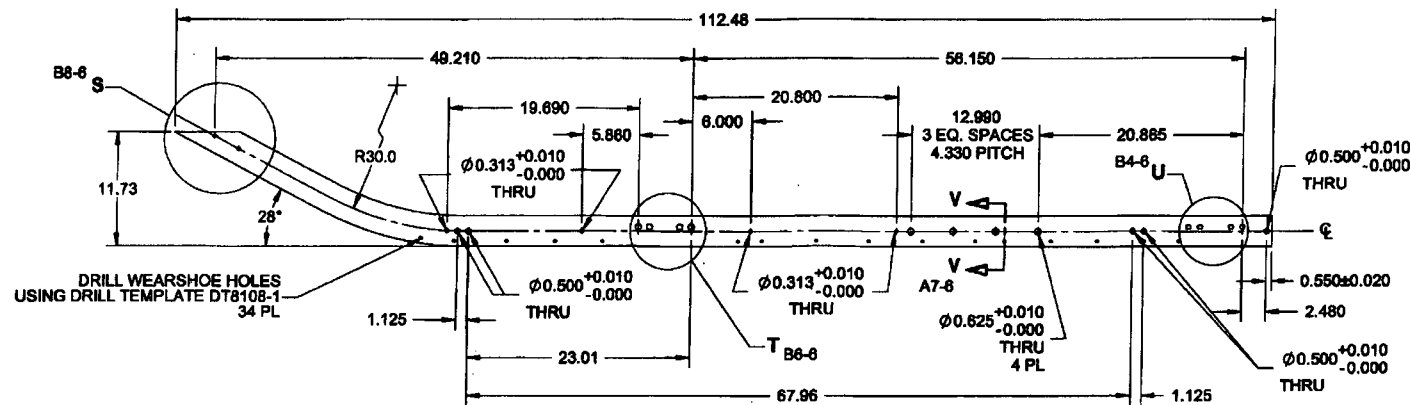


B3-5
SECTION R-R
SCALE 3X, 4 PL

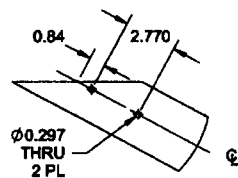
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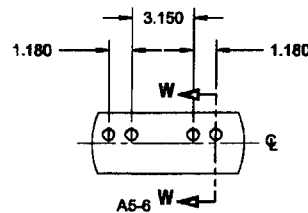
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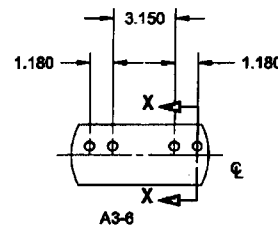
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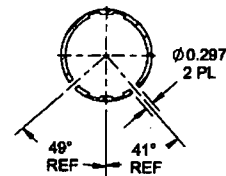
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SCALE 2X



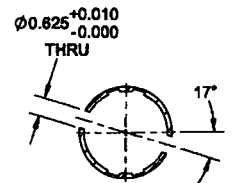
DETAIL T
C5-6
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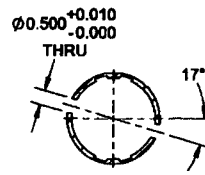
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL

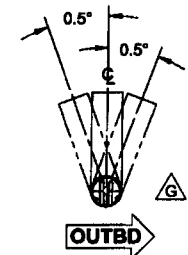
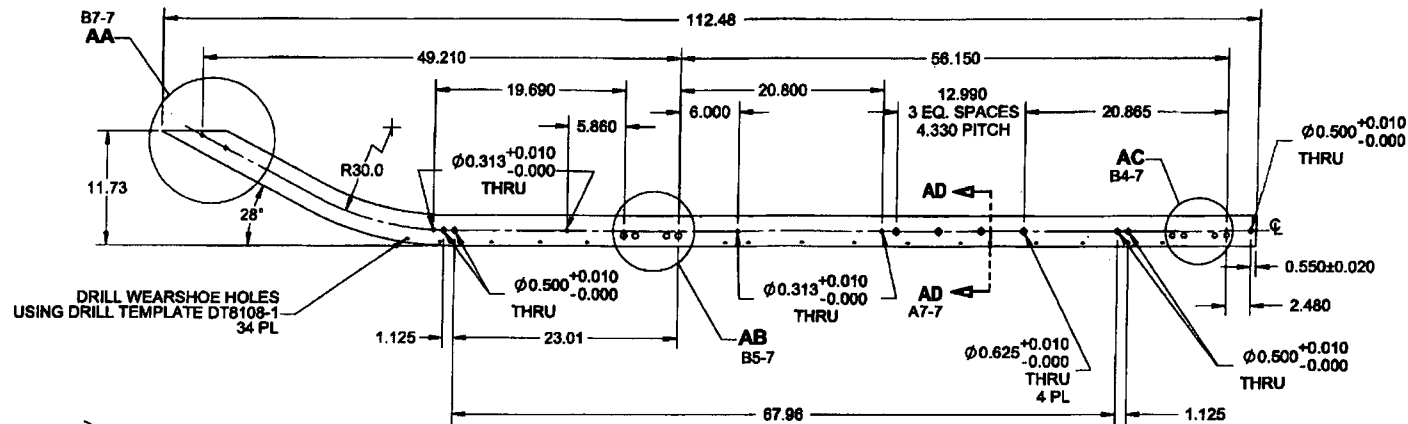


SECTION X-X
B4-6
SCALE 3X, 4 PL

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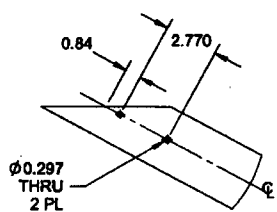
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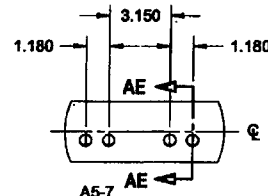


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

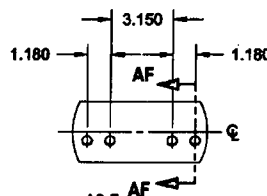
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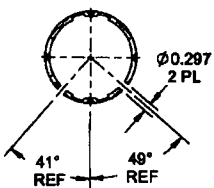
DETAIL AA
SCALE 2X



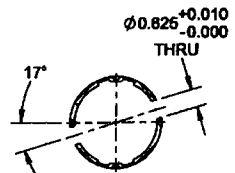
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SCALE 2X



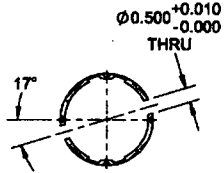
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



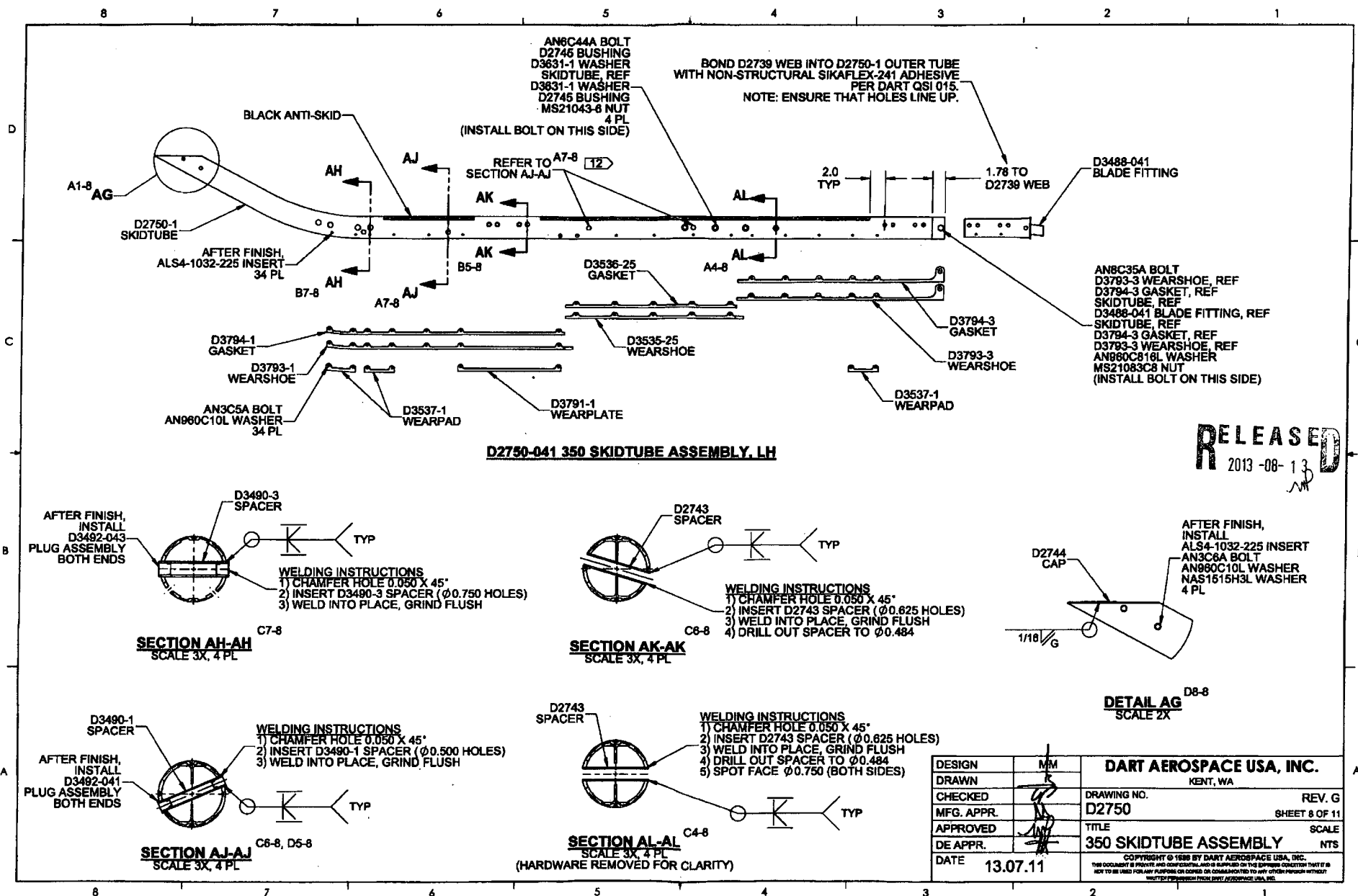
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SCALE 3X, 4 PL



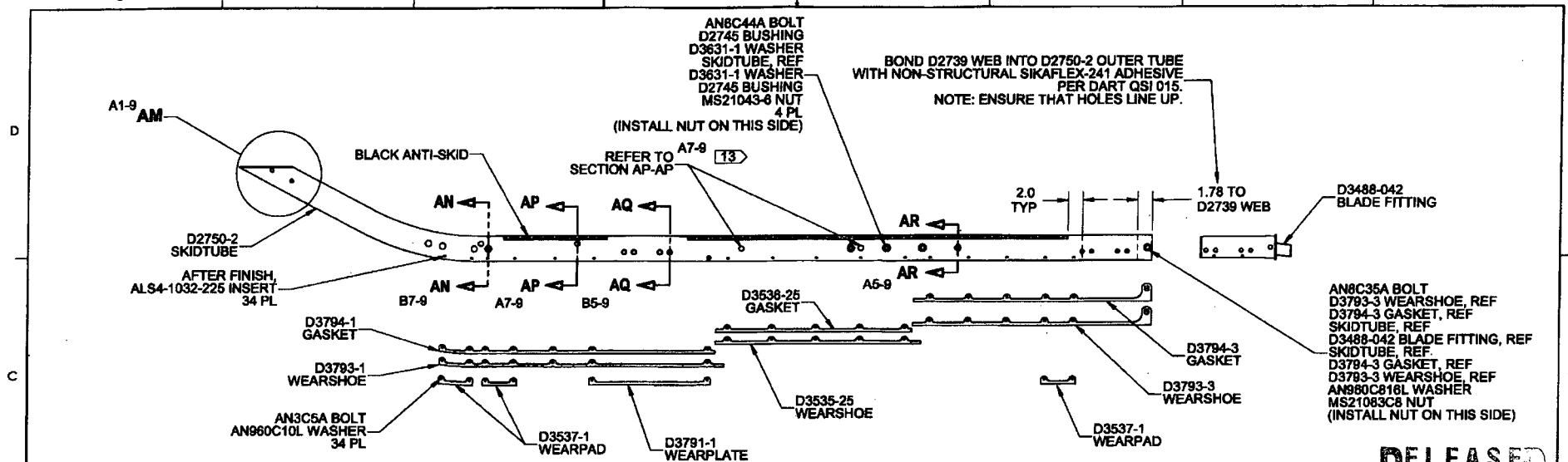
SECTION AF-AF
SCALE 3X, 4 PL

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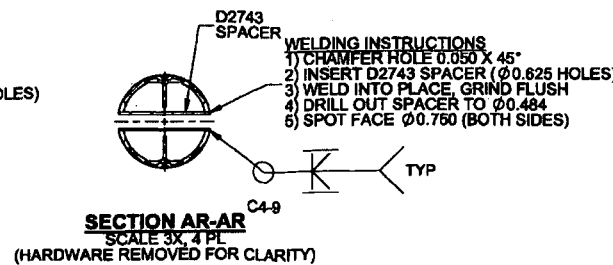
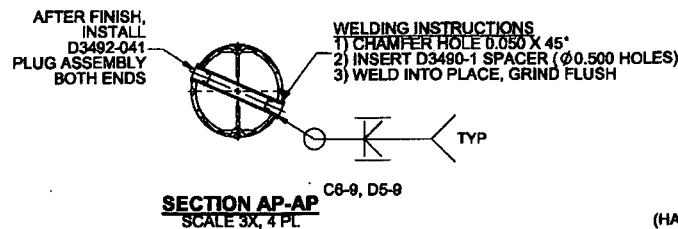
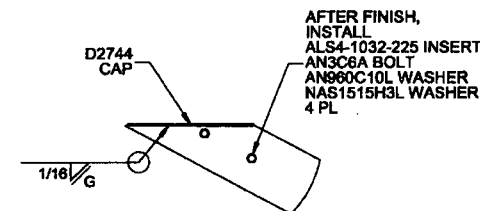
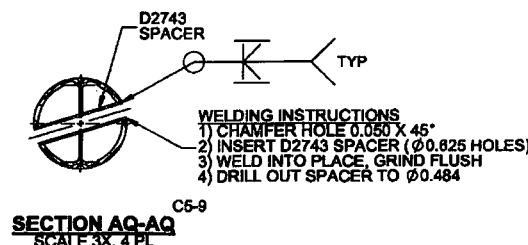
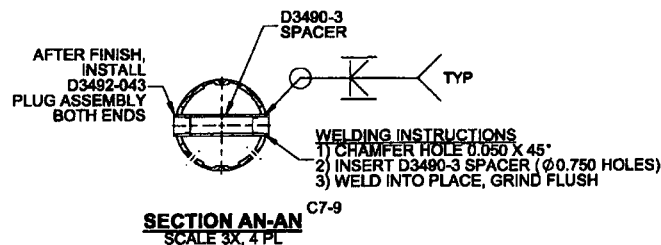


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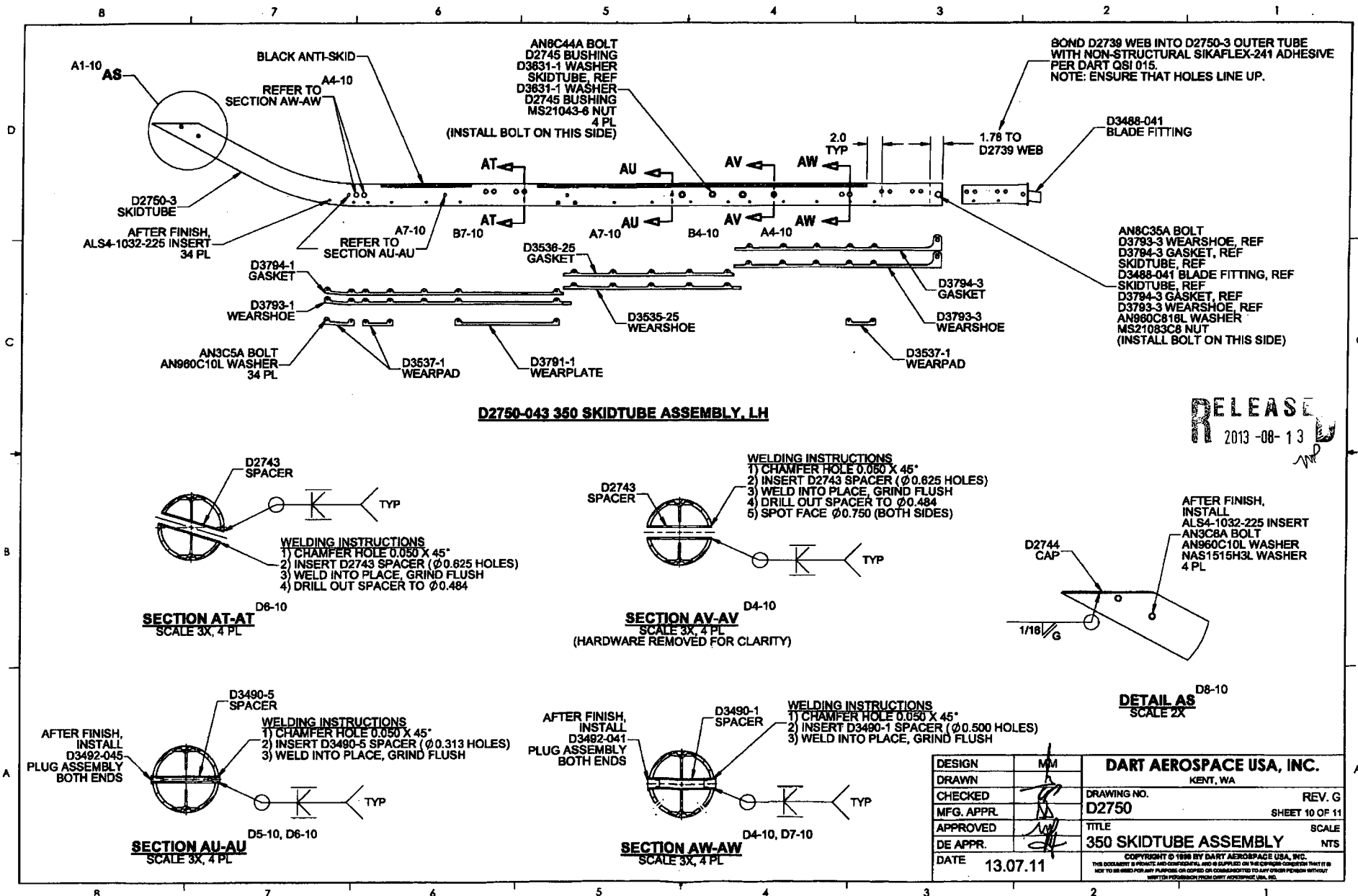


D2750-042 350 SKIDTUBE ASSEMBLY, RH

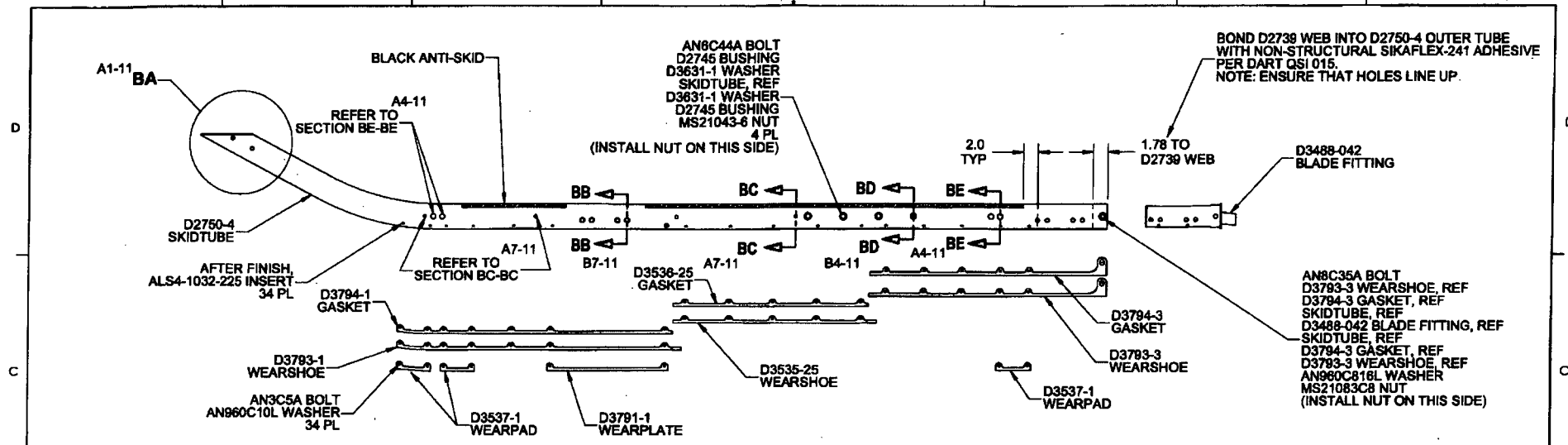
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2013-08-13



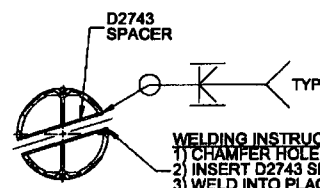
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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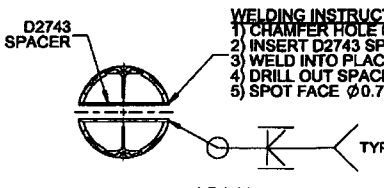
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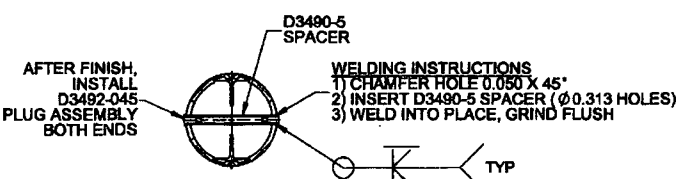
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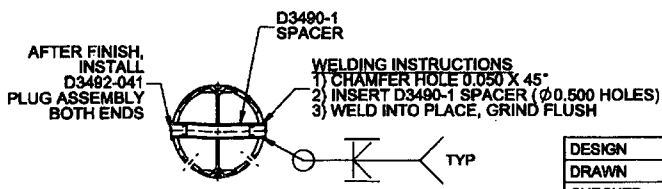
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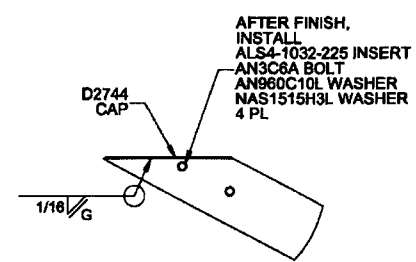
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(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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